

# Work Order ID 110150

\*110150\*

Page 1

December-17-13 9:16:29 AM

Item ID: D3913-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Long Basket Base Assembly, 350  
 Start Date: 12/12/13 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 12/17/13 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 13-12-18 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3913	C								
D4020	A								
100	Weld per dwg A/R S.S. rod Batch: <u>B123823</u>	0.00							
*100*	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4- Weld D4672-1 blanking plates as per dwg								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
*110*	QC								
Quality Control	Memo	0.00							

1x CC 14-1-17

① 14-01-17

DAS  
9  
9-89

December-17-13 9:16:29 AM

**Item ID:** D3913-041

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Revision ID:

**Item Name:** Long Basket Base Assembly, 350

Stop \*NS2\*

**Start Date:** 12/12/13      **Start Qty:** 1.00

**\*1\***

**Cust Item ID:**

**Required Date:** 12/17/13      **Req'd Qty:** 1.00

**\*1\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/  
Work Center ID

### Operation Description

### Set Up/ Run Hours

Tool ID

Tool #

**Plan  
Code**

Accept	Qty
--------	-----

Reject  
Qty

### Reject Number

**Insp.  
Stamp**

120

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

## Memo

0.00

## Quality Control

① 14-01-17 DAS  
9  
9-89

125

Pressure Wash per QSI005 4.3

0.00

**\*125\***

HandFinish

## Memo

0.00

## Hand Finishing

1 HG 141-20

## December-17-13 9:16:29 AM

**\*110150\***

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**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 12/12/13      **Start Qty:** 1.00      **\*1\***

**Cust Item ID:**

**Required Date:** 12/17/13      **Req'd Qty:** 1.00      **\*1\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_      **Date:** \_\_\_\_\_      **Tooling:** \_\_\_\_\_      **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

**Insp.  
Stamp**

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

**\*130\***

M 26829.

0.00

Powdercoat

## Memo

0.00

## Powder Coating

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME:

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: 1:45

\*\*\*\*\*2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME:

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME:

140

### QC3- Inspect Part Finish

0.00

**\*140\***

0.00

QC

## Memo

0.00

### Quality Control

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**\*1 10150\***

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**\*N900040100\***

**Setup Start \*NS1\***

Stop \*NS2\*

**Start Date:** 12/12/13      **Start Qty:** 1.00      **\*1\***

**Cust Item ID:**

**Required Date:** 12/17/13      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

**Insp.  
Stamp**

Assemble as per dwg

0.00

**\*150\***

## Memo

0.00

HandFinish

## Pick Kit

## Hand Finishing

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

## Memo

0.00

OC

## Quality Control

Identify as per dwg & Stock Location: W/O

0.00

**\*170\***

## Memo

0.00

### Packaging

## Packaging

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**\*1 10150\***

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**\*N900040100\***

**Setup Start \*NS1\***

Stop \*NS2\*

**Start Date:** 12/12/13      **Start Qty:** 1.00      **\*1\***

**Cust Item ID:**

**Required Date:** 12/17/13      **Req'd Qty:** 1.00      **\*1\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

## Memo

0.00

### Quality Control

14-01-22

14-01-21

# Picklist Print

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Page 1

Work Order ID: 110150

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 12/12/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP  
REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3913-1 Rib		Manufactured	No			100	Each	3.0000	1	1		CC 14-1-9	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		3							
				103617		1							
				103755		2							
D3913-3 Rib		Manufactured	No			100	Each	0.0000	1	1		CC 14-1-9	
D3913-7 Rib		Manufactured	No			100	Each	3.0000	2	2		CC 14-1-9	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		3							
				94828		3							
D3913-9 Hinge Rib		Manufactured	No			100	Each	0.0000	1	1		CC 14-1-9	
D3916-5 Light Rib		Manufactured	No			100	Each	9.0000	3	3		CC 14-1-9	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		9							
				107317		8							
				107318		1							
D3916-041 Rib Assembly		Manufactured	No			100	Each	6.0000	2	2		CC 14-1-9	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		6							
				106740		4							
				107999		2							

# Picklist Print

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Work Order ID: 110150

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 12/12/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

D4017-7      Manufactured      No      100      Each      20.0000      3      3      CC 14-1-9

Rib

Location	Loc Qty	Loc Code
WA004	20	
106799	2	
107296	18	

D4017-9      Manufactured      No      100      Each      4.0000      2      2      CC 14-1-9

Rib

Location	Loc Qty	Loc Code
WA004	4	
107394	4	

D4034-041      Manufactured      No      100      Each      5.0000      1      1      CC 14-1-9

Aft Upper Rib Assembly

Location	Loc Qty	Loc Code
WA004	5	
106006	1	
106357	4	

D4034-043      Manufactured      No      100      Each      5.0000      1      1      CC 14-1-9

Fwd Upper Rib Assembly

Location	Loc Qty	Loc Code
WA001	4	
106655	4	
WA004	1	
105994	1	

D2581      Manufactured      No      100      Each      264.0000      2      2      CC 14-1-9

Mounting Bracket

Location	Loc Qty	Loc Code
WA004	264	
102265	94	
103683	98	
105886	48	
107768	24	

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Shop Packet Print

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# Picklist Print

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Work Order ID: 110150

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 12/12/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

D2931	Manufactured	No	150	Each	2,080.0000	2	2	<del>32</del> 9-89
Bumper								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

GA	82	
46064	82	
ST021	1998	
86435	1998	

86435

D3913-15	Manufactured	No	100	Each	30.0000	1	1	CC 14-1-9
Wide Handle Plate								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA004	30	
102500	4	
102934	4	
103568	8	
107769	14	

1x

D4016-1	Manufactured	No	100	Each	48.0000	3	3	CC 14-1-9
Hinge Half, Base								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA004	48	
104200	20	
106646	20	
107938	8	

3x

D4021-1	Manufactured	No	100	Each	35.0000	3	3	CC 14-1-9
Handle Plate								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA004	35	
103509	7	
107253	12	
107621	8	
108008	8	

3x

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# Picklist Print

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Work Order ID: 110150

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 12/12/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

D4021-5  
Blanking Plate

Manufactured No

100 Each 18.0000

2 2

DAS  
32  
9.89

Location

Loc Qty

Loc Code

ST083

18

103829

6

107129

3

107549

8

85065

1

107549

D4020-11  
End Mesh, Basket

Manufactured No

100 Each 16.0000

2 2

CC 14-1-9

Location

Loc Qty

Loc Code

WA004

16

100330

16

2x

D4672-1  
Blanking Plate

Manufactured No

100 Each 19.0000

2 2

CC 14-1-9

Location

Loc Qty

Loc Code

WA004

19

100820

8

107975

11

2x

M304EX0.75-16F  
Expanded Metal Flat SS

Purchased No

100 sf 1,316.2736

33 33

Location

Loc Qty

Loc Code

WA004

1316.273598

M126052

39.4435977

M126500

73.83

M126899

99

M127024

640

M127403

464

23

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# Picklist Print

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Work Order ID: 110150

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 12/12/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Purchased

No

150

Each

1,287.0000

2

2

2

Cherry Rivets

## Location

## Loc Qty

## Loc Code

ST311

1154

112794

40

122151

4

122452

4

123525

282

124231

91

m127476

733

WA003

133

107939

133

MS21042L3

Purchased

No

150

Each

6,342.0000

6

6

Nut

## Location

## Loc Qty

## Loc Code

GA

194

M126333

194

ST314

28

M126036

28

ST506

793

123900

793

ST509

4000

M127304

1000

M127410

3000

ST510a

1327

M126275

8

M126333

1319

m127476

m127476  
DAS 32 9-89

14/01/20 (1)

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# Picklist Print

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Work Order ID: 110150

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 12/12/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

150

Each

5,834.0000

12

12

DAS  
32  
9-89

Washer

Location

Loc Qty

Loc Code

GA

182

122063

182

ST294

158

122063

158

ST295

494

123352

3

123900

491

ST510a

5000

125646

5000

M128696

AN3-10A

Purchased

No

150

Each

187.0000

6

6

DAS  
32  
9-89

Bolt

Location

Loc Qty

Loc Code

ST351

4

124221

3

124858

1

ST513

183

m125709

183

125709

NAS1149DN832J

Purchased

No

150

Each

2,507.0000

2

2

DAS  
32  
9-89

Washer

Location

Loc Qty

Loc Code

ST293

20

M126221

20

st510

398

124555

398

ST510a

2089

M126319

1089

M127255

1000

M126319

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Shop Packet Print

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DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

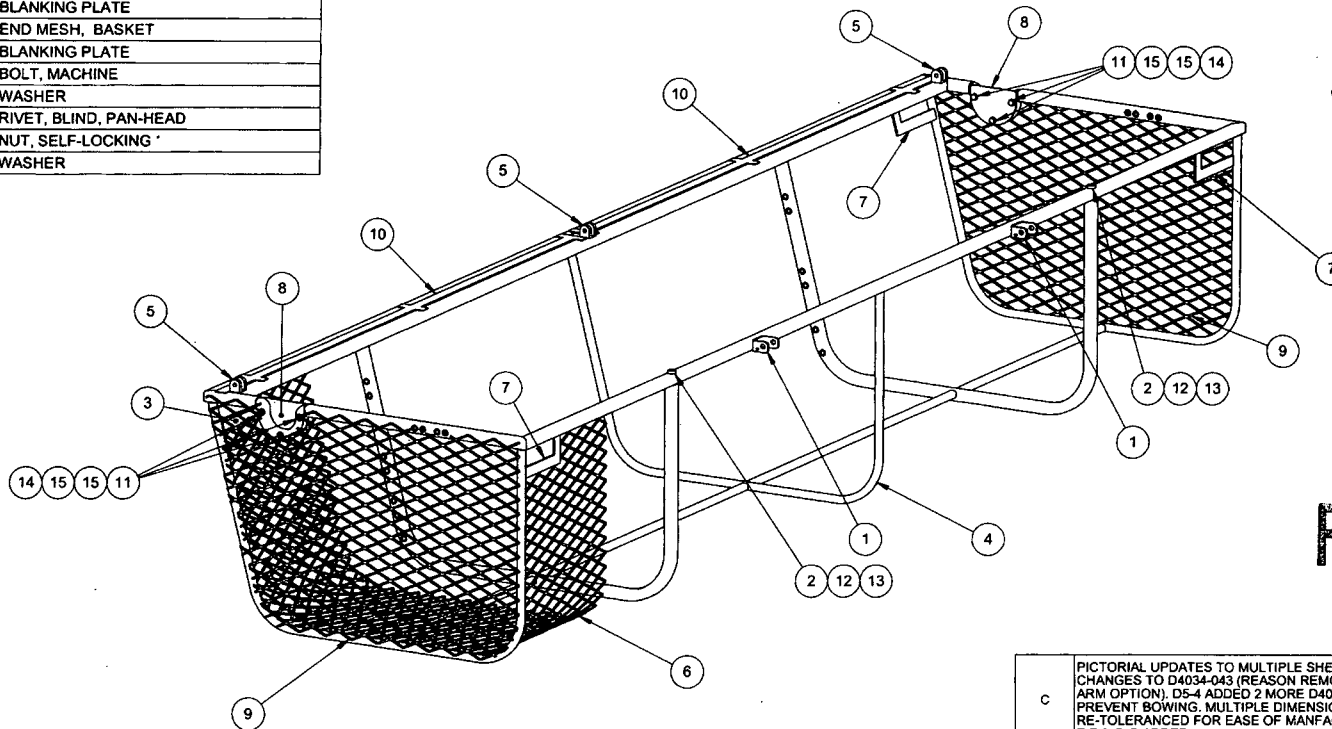
Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	2	D2931	BUMPER
3	1	D3913-15	WIDE HANDLE PLATE
4	1	D3913-101	TUBULAR ASSY (350 LONG BASKET)
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	3	D4021-1	HANDLE PLATE
8	2	D4021-5	BLANKING PLATE
9	2	D4020-11	END MESH, BASKET
10	2	D4672-1	BLANKING PLATE
11	6	AN3-10A	BOLT, MACHINE
12	2	AN960JD8	WASHER
13	2	MS20600AD4W3	RIVET, BLIND, PAN-HEAD
14	6	MS21042L3	NUT, SELF-LOCKING
15	12	NAS1149F0332P	WASHER



**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

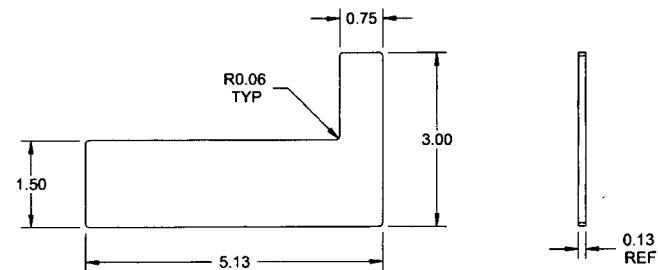
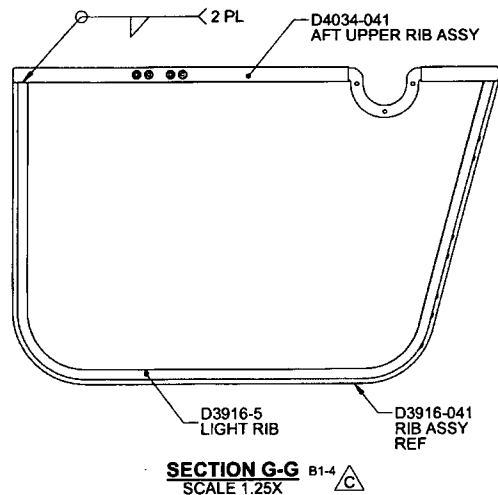
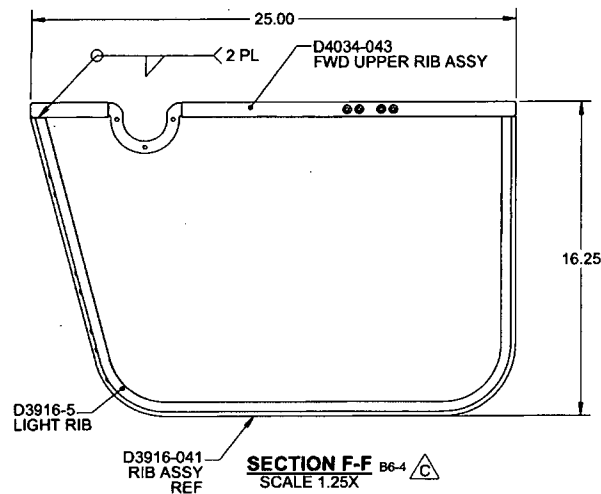
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.9 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

110158 MJS  
13-12-18

**RELEASED**  
2013-08-16

C	PICTORIAL UPDATES TO MULTIPLE SHEETS FOR CHANGES TO D4034-043 (REASON: REMOVAL OF PROP ARM OPTION). D5-4 ADDED 2 MORE D4017-7 RIBS TO PREVENT BOWING. MULTIPLE DIMENSIONS RE-TOLERANCED FOR EASE OF MANUFACTURE. SECTION F-F & G-G ADDED.	AJS	13.07.18
B	ADD D4672-1 (2N C4-1, C8-1, D2-2, D2-3, & D5-2). REASON: PART 12-197.	MB	12.06.15
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	UP	DRAWING NO.	REV. C
MFG. APPR.	MJS	D3913	SHEET 1 OF 6
APPROVED	MJS	TITLE	SCALE
DE APPR.	MJS	LONG BASKET BASE ASSY (350) NTS	
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



#### D3913-15 WIDE HANDLE PLATE

#### NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH.  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

**RELEASED**  
2013-08-16

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
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